

Date:
User:

Thursday, 14/06/2007 10:30:20 AM
Linda Lacelle

Rush - must ship 22/06

Dart Aerospace Ltd.

Split into 80 57 10/19

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 32909 -1

Estimate Number : 12336

P.O. Number : *N/A*

This Issue : 14/06/2007 S.O. No. :

Prsht Rev. : NC

First Issue : 11 Type : SMALL / MED FAB

Previous Run : 32909

Written By :

Checked & Approved By :

Comment :

Est: C 99.06.23 Returned to Electro Polish DM
Est Rev:D Now on WaterJet 07-06-14 JLM

Drawing Name : 206 L/L 1/L3 SCUFF PLATE, AFT LH

Part Number : D206555007

Drawing Number : D206-555 REV C

Project Number : N/A

Drawing Revision : C

Material : *N/A*

Due Date : 22/06/2007

Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Type Labels as per PPP D206-555-007

2.0 M304S25GA

304/316 .020" Sheet



Comment: Qty.: 0.4410 sf(s)/Unit Total: 4.4100 sf(s)

304/316 .020" Sheet

Batch: *M103 504*

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

3.0 Waterjet/Kader 3AD 07/06/14 (10)

Form parts on hydraulic press as per Dwg. D206-555 using DT8320-7

Finish form on bench forming Jig DT8321-7

Remove tooling tabs and deburr

SB 07/00/19

SB 07/00/15

FF 07-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/19	5	Split into	SS	07/10/19	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L/L 1/L3 SCUFF PLATE, AFT LH

Job Number: 32909

Part Number: D206555007

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/10/19 13

W 02/10/19

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub Contracting Outside services

Electrochemically polish per ASTM B912, High shine finish, No scratches on surfaces.

Issue P/O:

Possible supplier: TQF Technologies

P/O

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/10/19 54 ①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

7/10/19 54 ①

11.0

QC21

FINAL INSPECTION/W/O RELEASE



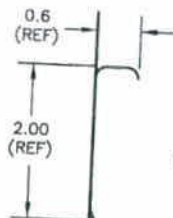
Comment: FINAL INSPECTION/W/O RELEASE

7/10/19 ①

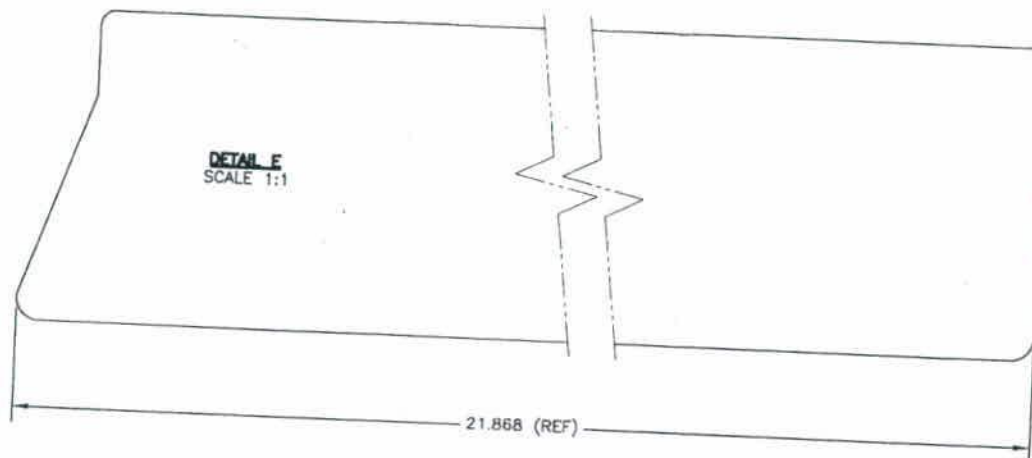
Job Completion



h 57.10.19

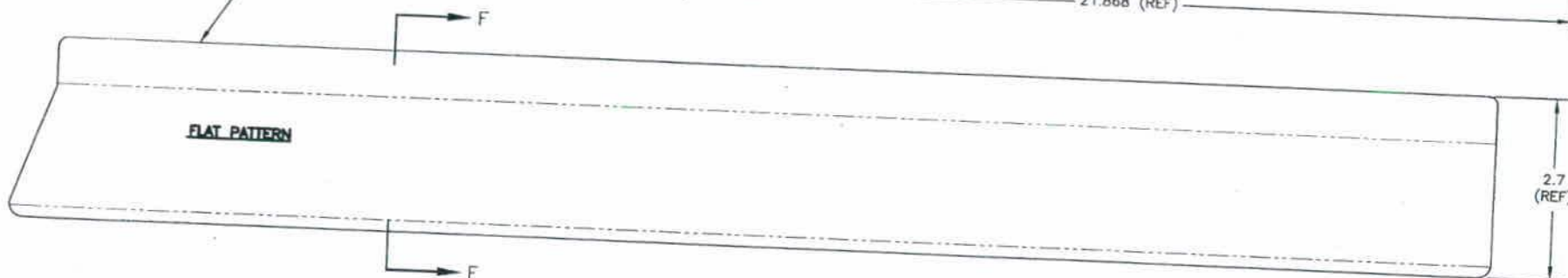


SECTION F-F
DETAIL OF
BENDING SHOWN



DETAIL E
SCALE 1:1

REFER TO DETAIL E
FOR 1:1 SCALE



FLAT PATTERN

2.7
(REF)

D206-555-007 (BEND IN DIRECTION SHOWN IN SECTION F-F)

NOTES

- 1) BEND PER M/F TEMPLATE D206-555-T7
- 2) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.020 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH
(REF. DART SPEC. M304S25GA)
- 3) FINISH: ELECTROCHEMICALLY POLISH PER ASTM B912 (OR EQUIVALENT), HIGH SHINE FINISH. NO SCRATCHES ON SURFACES *SEE W/O CHANGES*
STEP 7.0
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

06.09.19 *[Signature]*

DESIGN JB	DRAWN BY <i>[Signature]</i>	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-555	REV. C
DATE 06.09.01		TITLE DOOR SILL SCUFF PLATES	SHEET 5 OF 7 SCALE 2:3

Description: Beef Plate

Work Order: 32909

Inspection Dwg: 11266-555 Rev: C

Part Number: D2GE 355 00

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☐ Prototype

ISO 9001:2015 Quality Assurance approved QA/FA-B Rev A

Dart Aerospace Ltd

(000)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-06-18	7.0	Hand Polish using a buffer: Walter's blue & white metal Polish. Blue # WAL 07T905 M104786 AIR White WAL 07T906 M104789 AIR Dwg to be updated.				<i>[Signature]</i> 07-06-18	<i>[Signature]</i> 07-06-18
07/01/19 07/10/19	7 7	Split w 1.0 split w 1.0	SB 07/01/19 SB 07/10/19		9		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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